



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A94-2706-00-01

Job Sheet 197520



Part No: RBE350A94-2706-00-01

Job Qty: 50 pcs

Part Name: Pin



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/10/19

Job Tracking No:

Due Date: 9/2/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A94-2706-00 REV 6 IPP REV A 18-01-16 NEW ISSUE JFC VERIFIED DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	50 pcs	9/2/19		0.00	3.33	Small Fab - 1		GP 19-09-19.
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	50 pcs	9/2/19		0.00	0.00	QC 5 - 10		SFP 19 2019 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
121	Outsource - 12 - Black Oxide	50 pcs	9/2/19				GRO002-VC	10	2019-09-23
123	Packaging 2-1 - Recelve - B4B	50 pcs	9/2/19		0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		

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				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
125 QC 6	50 pcs	9/2/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
127 Small Fab - 2 - B4B	50 pcs	9/2/19	0.00 4.17	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
129 QC 5	50 pcs	9/2/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	

SEP 26 2019

DAS
81
9-89

OCT 07 2019

GP 19-10-11

					QC 5 - 30	DAS 40 9-89
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
130 Packaging 3-1 - Stock - B4B	50 pcs	9/2/19	0.00	0.00	Packaging 3 - 1 - B4B	DAS 28 8-89
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	50 pcs	9/2/19	0.00	0.00	QC 21 - SA - 21	DAS 21 8-89
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 110 - Small Fab-3 (Small Fab) - Assemble as per DWG. Sheet 2 - Loctite 680 B

Exp: _____

Descriptions: 120 - QC5 (QC5- Inspect part completeness to step on W/O)

121 - Issue P/O to Groupe Altech; PO 44559 - Black oxide finish, MIL-C-13924C Class 1 - Certificate of Conformity is required

123 - Packaging2 (Receive & Inspect for Damage & Mat'l Certs)Receive

125 - QC6 (QC6- All purchased or subcontracted products)

127 - Small Fab-8 (Small Fab) - Fabricate lanyard 6" inch and Assemble as per DWG

129 - QC5 (QC5- Inspect part completeness to step on W/O)

130 - Packaging3-1 (Identify as per dwg & Stock Location: _____)

140 - QC21 (QC21- Final Inspection - Work Order Release)

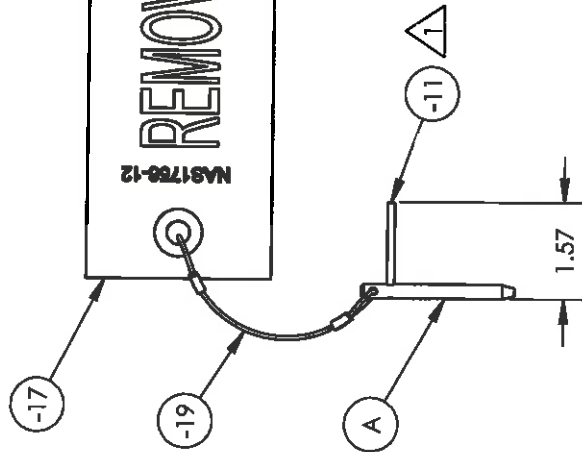
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
91595A142	Dowel Pin Ø3mm x 40mm <i>51</i>	50 Ea (1 ea)	110-Small Fab - 1	<i>5199325</i>
RBE350A94-2706-00-01A	Pin Shaft <i>141A</i>	50 pcs (1 ea)	110-Small Fab - 1	<i>5192108</i>
3896T31	Ferule 1/16 X 3/8" - Aluminum <i>26</i>	100 Ea (2 ea)	127-Small Fab - 2 - B4B	<i>5199293</i>
CL-2-C	Lanyard Wire <i>26/32</i>	25 ft (.5 ea)	127-Small Fab - 2 - B4B	<i>5190064</i>
NAS1756-12	Remove Before Flight <i>25</i>	50 Ea (1 ea)	127-Small Fab - 2 - B4B	<i>5200859</i>
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	91595A142	50	21	0
	RBE350A94-2706-00-01A	50	56	0
127-Small Fab - 2 - B4B	3896T31	100	519	0
	CL-2-C	25	1,241	0
	NAS1756-12	50	134	0
Part Specifications				
Specifications could not be found.				

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REV		ECR		REVISIONS	
6		14-0281		DESCRIPTION	
				-01, -03, -05, -07, -09 ADDED FINISH SPEC QSM4-2.2. B.O. REV D. ADDED -17, -19, NOTE A.	
				DATE 1/12/2017	
				INITIAL RUC	
				APPROVED JAG	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197520 MWS
19 07-10



REMOVE BEFORE FLIGHT

ASSY P/N	A P/N
-01	-01A
-03	-03A
-05	-05A
-07	-07A
-09	-09A

NOTE:

USE LOCTITE 680 TO ASSEMBLE.



RIGGING PIN SET

TITLE		REV	
RBE350A94-2706-00-01		6	
DWG NO.			
MATERIAL			
HEAT TREAT			
FINISH			
BLACK OXIDE			
SPEC QMSI-6.2.2, B.O. REV D			
DRAWN BY: PERRITT			
CHECKED: DUERFELDT			
OPPS APPR: ANDERSON			
QA APPR: LINDSAY			
APPROVED: GILBERT			
SCALE 1:3		DATE 9/11/2009	
		EUROCOPTER AS350/355	
		SHEET 2 OF 3	

-01, -03, -05, -07, -09

PIN

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS					
Date: _____		Sequence #: _____		QTY Affected: _____					
Description Work Order Deviation		Disposition		MRB (QS1042)					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____		Contamination Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
				Completed By Lead hand / Supervisor QC / QA Coordinator 					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044559



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044559

PO Date: 9/23/19

Due Date: 10/1/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-09-29

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	199047	RBW6510G05731-6F-2	Support -Issue P/O: -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MIL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed -		10/1/19	6 pcs	0 pcs	6 pcs	\$6.95/pcs	\$41.70
2	199141	RBW6522A00231-W142AJ-3T-5A	Insert (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed -		10/1/19	6 pcs	0 pcs	6 pcs	\$2.69/pcs	\$16.14



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PURCHASE ORDER

POHB044559



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	199037	RBW6510G04631-6F-6	Bracket -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed -		10/1/19	12 pcs	0 pcs	12 pcs	\$1.85/pcs	\$22.20
				X12							DP
											SEP 26 2019
4	197520	RBE350A94-2706-00-01	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed -		10/1/19	50 pcs	0 pcs	50 pcs	\$2.50/pcs	\$125.00
				X50							DP
											SEP 26 2019
5	199255	RBST4241-15	Locating Pin -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed -		10/1/19	12 pcs	0 pcs	12 pcs	\$1.23/pcs	\$14.76
				X12							DP
											SEP 27 2019
Grand Total:										\$219.80	



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Hawkesbury, ON
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Canada

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PURCHASE ORDER
POHB044559



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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Certificat de Conformité / Certificate of Compliance

(022664-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupealtech.com

Bon de Livraison / Packing Slip

022664 - 1

RECEIVED

SEP 26 2019

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA

Tel.: 613-632-5200 Fax.:

DART AEROSPACE LTD.

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
26-Sep-2019		Jigar Patel		POHB044559				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW6510G05731-6F-2 Rev.	RBW6510G05731-6F-2 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	6	6	0	0	0
2	RBW6522A00231-W142AJ-3T-5A Rev.	RBW6522A00231-W142AJ-3T-5A OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	6	6	0	0	0
3	RBW6510G04631-6F-6 Rev.	RBW6510G04631-6F-6 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	12	12	0	0	0
4	RBE350A94-2706-00-01 Rev.	RBE350A94-2706-00-01 SAND BLAST ALL OVER OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	50	50	0	0	0
5	RBST4241-15 Rev.	RBST4241-15 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	12	12	0	0	0

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.